

Work Order ID 101072-2

April-30-13 2:39:35 PM

\*101072\*

Page 1

Item ID: D4008-041

Revision ID:

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/30/13

Start Qty: 4.00

\*4\*

Required Date: 4/30/13

Req'd Qty: 4.00

\*4\*

Reference:

Approvals:

Process Plan: MLS

Date: 13-05-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

\*N9000040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4008

C

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D4008-1)

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

4

0

Ac  
13.06.26

4

0

Ac  
13.06.26

# Work Order ID 101072

April-30-13 2:39:35 PM

**\*101072\***

Page 2

Item ID: D4008-041      Accept      **\*N9000040100\***      Setup      Start      **\*NS1\***  
 Revision ID:      Stop      **\*NS2\***  
 Item Name: Fuel Filler Splash Guard Assembly  
 Start Date: 4/30/13      Start Qty: 4.00      **\*4\***      Cust Item ID:  
 Required Date: 4/30/13      Req'd Qty: 4.00      **\*4\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				4			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo Bend D4004-1 as per Dwg	0.00 0.00				4			8/ 13/06/27
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				④ 13-06-27			DAS 09 2-88



# Work Order ID 101072

April-30-13 2:39:35 PM

**\*101072\***

Page 3

Item ID: D4008-041  
 Revision ID:  
 Item Name: Fuel Filler Splash Guard Assembly  
 Start Date: 4/30/13 Start Qty: 4.00  
 Required Date: 4/30/13 Req'd Qty: 4.00  
 Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***  
 Stop **\*NS2\***

Cust Item ID:  
 Customer:

Approvals: Process Plan: Date: Tooling: Date:  
 QC: Date: SPC (Y/N):

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
150	Chemical Conversion Coat per QSI005 4.1	0.00

**\*150\***  
 HandFinish  
 Hand Finishing

Memo

0.00

155	QC7-Inspect Chemical Conversion Coat	0.00
-----	--------------------------------------	------

**\*155\***  
 QC  
 Quality Control

Memo

0.00

160	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00
-----	---------------------------------------	------

**\*160\***  
 Powdercoat  
 Powder Coating

Memo

0.00

\*\*\*REMOVE PIN PRIOR TO POWDERCOATING\*\*\*

Start Time:  
 Oven Temperature:  
 Finish Time:

9:00  
 320°F  
 9:30

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

4x ✓ 13/06/27

4x ✓ m-f 13/06/27

4x ✓ m-f 13/06/27

W118533

# Work Order ID 101072

\*101072\*

Page 4

Item ID: D4008-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/30/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 4/30/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

4 x 1 of all 13/06/22

180

0.00

\*180\*

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

3x [Signature] 13/06/22

190

QC5- Inspect part completeness to step on W/O

0.00

\*190\*

QC

Memo

0.00

Quality Control

15627

3





# Picklist Print

April-30-13 2:39:34 PM

Page 1

3

Work Order ID: 101072  
Parent Item: D4008-041  
Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	977.7700	0.2735	1.1515788			
<div> <div>* MATERIAL LABELLED</div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				MAT021		977.77							
				121099		171.94							
				122256		46.78							
				122737		44.8							
				123097		71.9							
				123135		37.7							
				123137		51.85							
				123293		58.5							
				123483		260.6							
				123701		47.85							
				124629		71.85							
				125341		114							
D3941 Rubber Cushion		Manufactured	No			180	f	33.9253	0.21	0.8842104			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST414		33.9252767							
				48512		33.9252767							
D4008-5 Fuel Filler Splash Guard Hinge Half		Manufactured	No				Each	3.0000					
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				GA		3							
				99188		3							
D4008-9 Spring		Manufactured	No			180	Each	11.0000	1	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				GA		11							
				97485		11							

MR26116, Computer says MR26115 \* MR26116

1.16 13.06 26

0.63 4 3/5/06/27

3 3/5/06/27

3 3/5/06/27

# Picklist Print

April-30-13 2:39:34 PM

Page 2

Work Order ID: 101072

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 4.00

Required Qty: 4.00

D4008-7 Washer Manufactured No

180 Each 22.0000 2 8

Location

Loc Qty

Loc Code

GA 1  
80629 1  
ST083 21  
100067 21

MS20470AD3-3 Rivet, Universal Head Purchased No

180 Each 6,217.0000 5 20

Location

Loc Qty

Loc Code

ST335 6217  
1065 1247  
16941 4970

MS21042L08 Nut Purchased No

180 Each 4,917.0000 2 8

Location

Loc Qty

Loc Code

ST315 2917  
122141 3  
122452 9  
122814 500  
123900 2405  
ST505 2000  
125445 2000

MS35206-S245 Screw Purchased No

180 Each 76.0000 2 8

Location

Loc Qty

Loc Code

ST289 76  
122459 76

April-30-13 2:39:35 PM

Shop Packet Print

Page 2

# Picklist Print

April-30-13 2:39:35 PM

Page 3

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Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 4.00

Required Qty: 4.00

NAS1149DN832J

Purchased

No

180

Each

3,663.0000

6

24

WASHER

## Location

## Loc Qty

## Loc Code

ST293

3489

123348

477

123352

200

123603

400

123900

12

124555

400

125268

2000

ST509

174

124093

174

18

4/30/13

April-30-13 2:39:35 PM

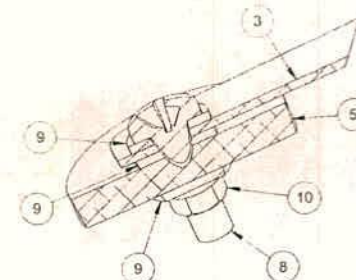
Shop Packet Print

Page 3



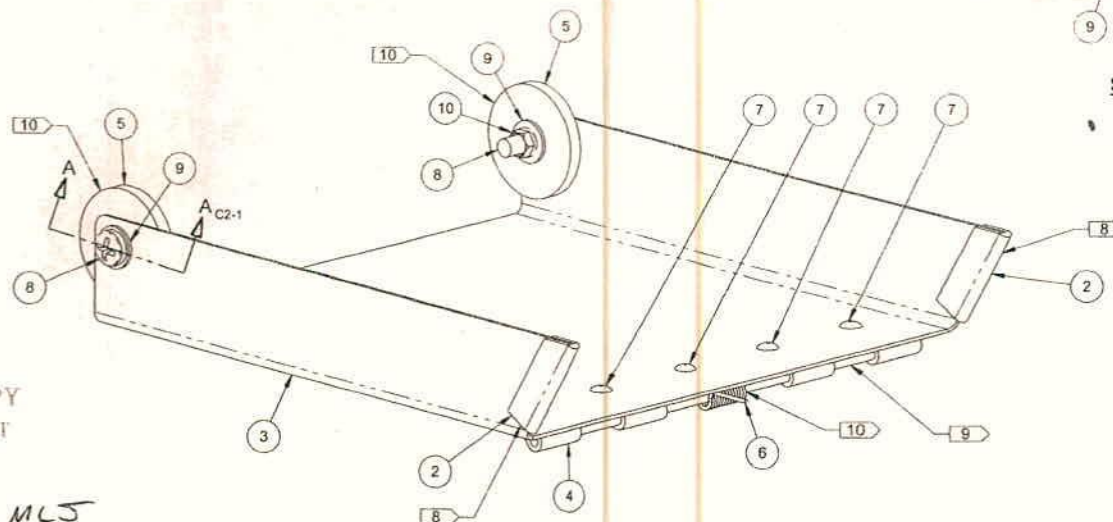


ITEM NO	QTY	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



# SECTION A-A

SCALE: 2X B6-1  
TYP



COPY  
STUDY  
PRINTING  
READ COPY  
REVISION  
NOTICE  
ORDER  
101032 MJS  
13-05-01

## D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

RELEASE  
2012-03-02

C	CHANGE POWDER COAT FROM "GREY SANDEXT" TO "ANSI 61 GREY". CORRECT MATERIAL ERROR, ZN A7-6. ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4008	SHEET 1 OF 10
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SPLASH GUARD	NTS
DATE	12.01.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



RELEASE  
2012-03-02

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.032

- 2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.11 lbs

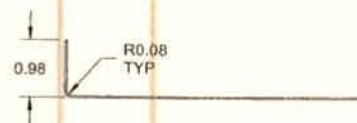
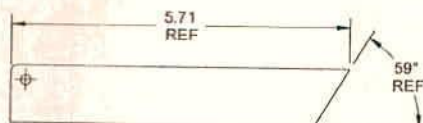
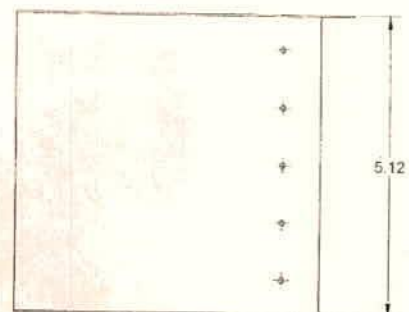
DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO <b>D4008</b>  TITLE <b>SPLASH GUARD</b>  COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS NOT TO BE LOANED, REPRODUCED, COPIED, OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. C
DRAWN	<i>JS</i>		SHEET 4 OF 10
CHECKED	<i>JS</i>		SCALE
MFG. APPR.	<i>JS</i>		NTS
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	12.01.17		

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DART AEROSPACE  
PART NUMBER  
D4008-1

JOHN CAMERON AVIATION  
PART NUMBER  
REF JCA-M47-2-26




# D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

RELEASED  
2012-03-02  
JWP

## NOTES:

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4008	SHEET 3 OF 10
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
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